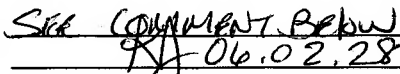


Date: Monday, 2/27/2006 4:17:53 PM
 User: Kim Johnston

Process Sheet

| | | | |
|------------------------------------|---|---------------------------|-------------|
| Customer : | CU-DAR001 Dart Helicopters Services | Drawing Name : | STRUT |
| Job Number : | 25969 | | |
| Estimate Number : | 10272 | | |
| P.O. Number : | N/A | Part Number : | D2562001 |
| This Issue : | 2/27/2006 | S.O. No. : | N/A |
| Prsht Rev. : | NC | Drawing Number : | D2562 REV D |
| First Issue : | N/A | Project Number : | N/A |
| Previous Run : | 24272 | Drawing Revision : | D |
| | Type : | Material : | N/A |
| | SMALL / MED FAB | Due Date : | 3/20/2006 |
| Written By : | Qty: | | 10 Um: Each |
| Checked & Approved By : |  | | |
| Comment : | Est F 02.04.15 Added dwg Rev.B1 NG | | |

Additional Product

Job Number:



| | | |
|----------------|------------------------------|----------------------|
| Seq. #: | Machine Or Operation: | Description : |
|----------------|------------------------------|----------------------|

| | | |
|-----|----------------|--------------------------|
| 1.0 | M304TR0500W035 | 304 RD Tube .500 x .035W |
|-----|----------------|--------------------------|



Comment: Qty.: 1.7920 f(s)/Unit Total: 17.9204 f(s)
 304/316/318-2B Seamless Tubing, 1/2" O.D. x 0.035" wall
 Batch H 19480

FF 06.04.12 10

| | | |
|-----|----------|----------|
| 2.0 | BRAKE NC | NC BRAKE |
|-----|----------|----------|



Comment: NC BRAKE
 Punch to length as per Dwg D2562

FF 06.04.12 10

| | | |
|-----|-------------|-------------------------------|
| 3.0 | SMALL FAB 1 | SMALL & MEDIUM FAB RESOURCE 1 |
|-----|-------------|-------------------------------|



Comment: SMALL/MED FAB RESOURCE
 1- Bend end as per Dwg D2562 Angle "D"
 2-Deburr

FF 06.04.21 10

| | | |
|-----|-----|------------------------------|
| 4.0 | QC5 | INSPECT WORK TO CURRENT STEP |
|-----|-----|------------------------------|



Comment: INSPECT WORK TO CURRENT STEP

06.04.23 10

| | | |
|-----|----------------|----------------|
| 5.0 | POWDER COATING | POWDER COATING |
|-----|----------------|----------------|





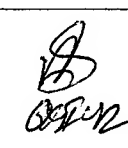
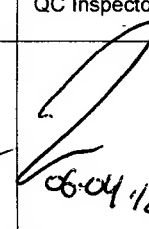
Comment: POWDER COATING
 Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

DL 06/04/24 10

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|----------|------|--|----|----------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| 06.04.12 | 2 | 10 struts one end damaged (good for shorter struts) | FP | 06.04.12 | 10 | | |
| | | | | | | | |
| | | | | | | | |

Part No: D2562-001 PAR #: N/A Fault Category: Prod / FAB. ASS ^{modification} NCR: Yes No DQA: DP Date: 06/04/2012
 QA: N/C Closed: HA Date: 06.04.2012

| NCR: <u>25869</u> | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|-------------------|------|---|--|--|----------------|--|--|--|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| 06.04.12 | 2 | Piece of Mat'l in strut punch left marks on the struts. Qty of 10 struts. Also dents. |  | Use the damaged struts for shorter struts. And replace the Qty of 10. Ensure punch is free of debris when using. | FP 06.04.12 |  06.04.12 |  |  06.04.12 |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Monday, 2/27/2006 4:17:53 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STRUT

Job Number: 25969

Part Number: D2562001

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

8.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



U 06.04.26

06/04/25 (10)

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

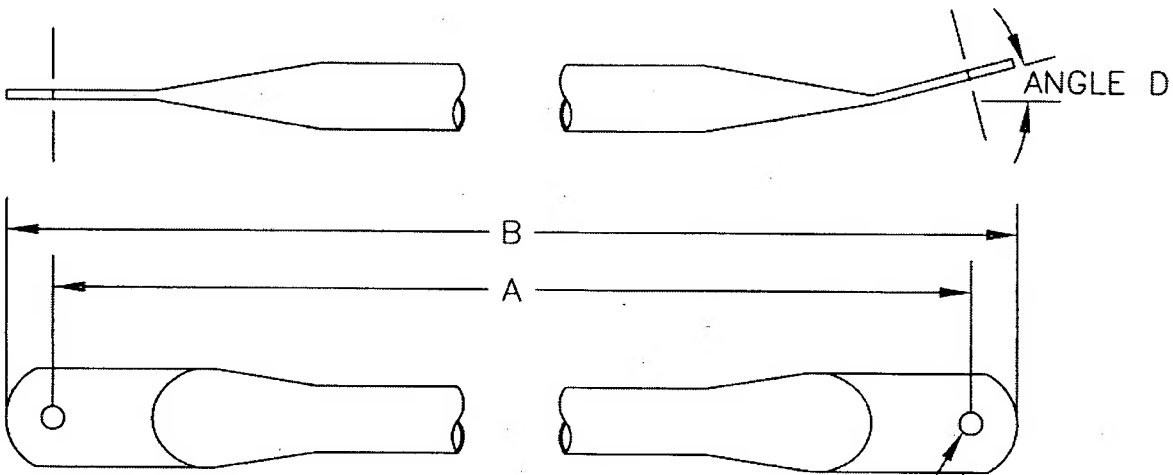
QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries



| DESIGN | CP | DRAWN BY | RF | DART AEROSPACE LTD |
|---------|--------------------|----------|----------------------------------|-----------------------------|
| CHECKED | <i>[Signature]</i> | APPROVED | <i>[Signature]</i> | HAWKESBURY, ONTARIO, CANADA |
| DATE | 05.05.18 | TITLE | D2562 | REV. D |
| | | | STRUT | SHEET 1 OF 1 |
| | | | | SCALE |
| A | | 96.05.01 | NEW ISSUE | 1:2 |
| B | | 98.10.15 | UPDATED MATERIAL NOTE (TSR A603) | |
| C | | 02.06.05 | ADD -005: ADD FINISH | |
| D | | 05.05.18 | ADD -007/-011/-013: UPDATE -005 | |



"C" DIA TO BE OPENED MANUALLY
PUNCH ENDS PER SPEC CONTROL DRAWING D2727

| PART # | DIM A | DIM B | DIA C | ANG D |
|-------------|-------|-------|-------|-------|
| ✓ D2562-001 | 19.68 | 20.48 | - | 10 |
| D2562-003 | 20.37 | 21.17 | - | 18 |
| D2562-005 | 29.00 | 29.80 | - | 30 |
| D2562-007 | 19.22 | 20.02 | - | 0 |
| D2562-011 | 25.79 | 26.59 | - | 16 |
| D2562-013 | 26.63 | 27.43 | - | 24 |
| | | | | |
| | | | | |
| | | | | |
| | | | | |

SHOP COPY
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ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 25969

GENERAL NOTES

- 1) MATERIAL: AISI 304/316/318 SS 0.500 OD X 0.035 WALL (REF DART SPEC. M304TR0.500W.035) ENSURE SEAMLESS TUBE IS USED
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

RELEASED

05.05.27

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